

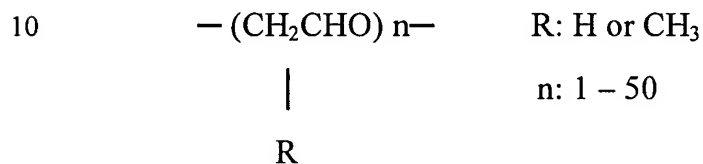
## CLAIMS

1. A process for producing a resin model used in precious casting by a lost wax method comprising at least:
  - 5 a hardened resin layer forming step of injecting two-pack reaction hardening type urethane resin solution (A) with a working life of 1 to 3 minutes through a casting port of a mold for resin model formation defining an internal space whose configuration is identical with that of a product into said internal space in a volume amounting to 5% to 20% of
  - 10 said volume of said internal space, closing said casting port and rotating said mold for resin model formation, so that a hardened layer of said two-pack reaction hardening type urethane resin solution is formed on an inside wall of said mold for resin model formation;  
a resin model forming step of repeating said hardened resin layer
  - 15 forming step three to six times at intervals of 3 to 5 minutes so as to effect laminating of hardened resin layers, thereby obtaining a resin model having internal space at a core region thereof; and demolding step of demolding said resin model from said mold for resin model formation.
- 20 2. A process for producing a resin model according to claim 1, wherein:  
said two-pack reaction hardening type urethane resin solution (A) comprises multifunctional polyol component (a), multifunctional polyisocyanate component (b) and a plasticizer component (c), and an
- 25 average functional group of said multifunctional polyol component (a) is

2.8 or larger, an average functional group of said multifunctional polyisocyanate component (b) is 2.0 or larger, and a ratio NCO/OH is within 0.7 to 1.0, and further said plasticizer component (c) is preferably micro-dispersed through phase separation at said reaction hardening.

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3. A process for producing a resin model according to claim 1 or 2, wherein said two-pack reaction hardening type urethane resin solution (A) contains polyether chains having a chemical structure indicated in chemical structural formula as follows at 2- 25 wt% thereof.



4. A process for producing a resin model according to any one of  
15 claims 1 to 3, wherein:

a fine wax component (d) is preferably contained within 5 to 40 wt% in said two-pack reaction hardening type urethane resin solution (A).

5. A process for producing a resin model according to any one of  
20 claims 1 to 4, wherein:

said resin model has an internal hollow space whose volume is in a range from 20% to 70% of volume of said resin model.

6. A process for producing a resin model according to claim 5,  
25 wherein said internal hollow space is filled with said wax component (d).

7. A process for producing a resin model according to claim 5, wherein said internal hollow space is filled with foamed urethane.
- 5 8. A process for lost wax precious casting wherein said resin model according to any one of claims 1 to 7 is used.